

BLUE

23

Wednesday, 5/16/2007 8:13:41 AM
Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	32380		
Estimate Number	10834	Part Number	D29332 <i>up</i>
P.O. Number	N/A	Drawing Number	D2933 REV C
This Issue	5/16/2007	Project Number	N/A
Prsh Rev.	NC	Drawing Revision	C
First Issue	N/A	Material	N/A
Previous Run	31251	Due Date	6/6/2007
Written By		Qty:	16 Um: Each
Checked & Approved By	<i>HP 07.05.16</i>		
Comment	Est: B 00-06-26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <i>B25345</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 32380

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SMK 07/06/09 (10)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

(4) 07-06-11/16

7.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

WRX

PR

8.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Stock unopened

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *440*

UP (12)

(D)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 07/11

Job Completion



(change to 'up' in spec) UFAWU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/15	9	Split to send to outside supplier for part	u	07/06/15	1	u	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.119	.119	.119		
B	0.100	0.140		.119	.120	.120	.119		
C	0.100	0.140		.124	.120	.120	.119		
D	0.210	0.230		.222	.221	.221	.221		
E	1.245	1.255		1.256	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.232	.239	.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.440	2.490		
S	0.240	0.270		.252	.251	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.137	1.137	1.136	1.137		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	En	Audited by:	DK
Date:	07/05/21	07/06/21	Date:	07/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JK

DART AEROSPACE LTD				Work Order:	32380
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.122	.121	.120		
B	0.100	0.140		.120	.126	.120	.119		
C	0.100	0.140		.121	.119	.120	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.519	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.119	.119	.119	.120		
O	0.540	0.560		.549	.549	.550	.550		
P	0.490	0.510		.501	.499	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.251	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.636	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.136	1.135	1.137	1.140		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.576	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L	CR	Audited by:	GML
Date:	07/05/28	/07/06/07	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.120		
B	0.100	0.140		.120	.120	.120	.116		
C	0.100	0.140		.121	.121	.119	.125		
D	0.210	0.230		.221	.220	.219	.224		
E	1.245	1.255		1.256	1.256	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.548	.550	.550	.550		
P	0.490	0.510		.501	.502	.502	.504		
Q	3.715	3.725		3.720	3.720	3.717	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.250	.252	.256		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L / J.F. /	Audited by:	OMR
Date:	07/05/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

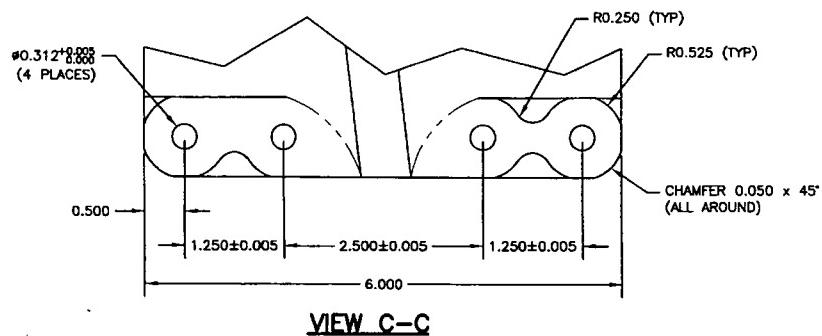
DART AEROSPACE LTD			Work Order:	32380
Description: 206 Saddle, Inboard, Right side			Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.117"	.120"	.121"	.119"		
B	0.100	0.140		.117"	.122"	.122"	.121"		
C	0.100	0.140		.125"	.125"	.125"	.125"		
D	0.210	0.230		.224"	.225"	.223"	.225"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"		
I	1.572	1.582		1.579"	1.579"	1.579"	1.579"		
J	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
K	0.257	0.262		0.259"	0.259"	0.259"	0.259"		
L	0.312	0.317		0.313"	0.313"	0.313"	0.313"		
M	0.235	0.240		0.239"	0.239"	0.239"	0.239"		
N	0.100	0.140		.120"	.118"	.119"	.121"		
O	0.540	0.560		.552"	.550"	.547"	.550"		
P	0.490	0.510		.504"	.505"	.504"	.505"		
Q	3.715	3.725		3.720"	3.720"	3.720"	3.720"		
R	2.470	2.510		2.490"	2.490"	2.490"	2.490"		
S	0.240	0.270		.256"	.256"	.256"	.255"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.370"	1.370"	1.370"	1.370"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.135"	1.136"	1.132"	1.138"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		B.188"	B.188"	B.188"	B.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.	/	Audited by:	✓
Date:	07/05/29	/	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM ✓	✓

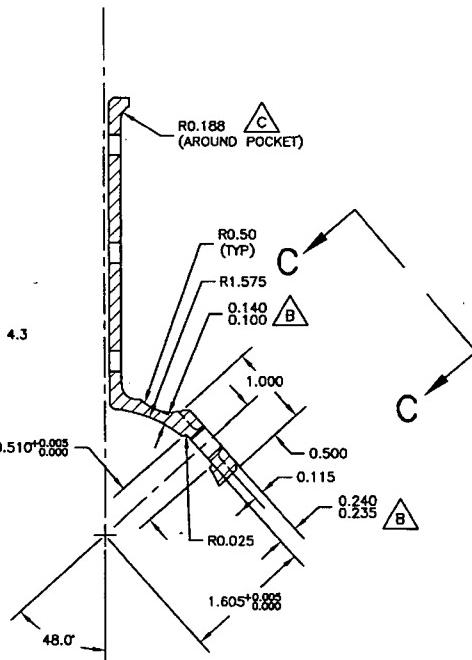


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

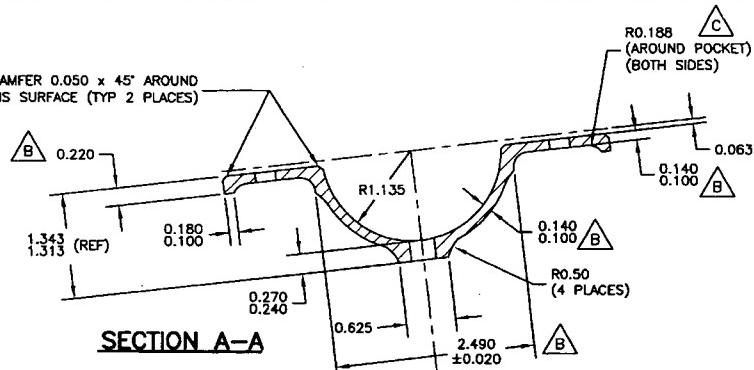
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QO-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QS 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

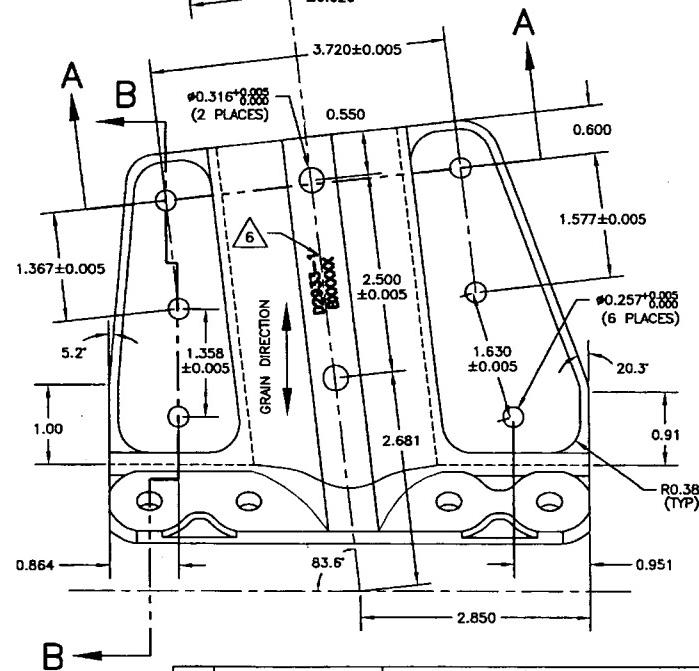


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



B

A

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
PH	CB	DRAWING NO. D2933 REV. C SHEET 1 OF 1
DATE		TITLE SADDLE INSIDE SCALE 2:3
06.11.09		

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